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5114523

20NR-26
Job Sheet 183899



Part No: 20NR-26

Job Qty: 20 ea

Part Name: Round Bumper



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/28/18

Job Tracking No:

Due Date: 10/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: 20NR-26 REV.A IPP REV:A 17.11.15 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		10/3/18	0.00	0.00	Start Up Machining-2		DAS 18/9/28
100	Small Fab	20 pcs		10/3/18	0.00	2.00	Small Fab-3		58 9-89
120	QC	20 pcs		10/3/18	0.00	0.00	QC5		MB
130	Packaging	20 pcs		10/3/18	0.00	0.00	Packaging3-2		21 SEP 28 2018
140	QC21-SA	20 Ea		10/3/18	0.00	0.00	QC21		9-88

Part Op Descriptions: 100 - 1- CUT TO SIZE AND CHAMFER AS PER DWG ***Hole in center no longer required see engineering for sign off***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
8695K715	Polyurethane Rod 3/4 DIA. 80A (HARD)	2.5000 ft (.125 ea)	90-Start up Operation	5080842

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	8695K715	3	13	0

Part Specifications

Specifications could not be found.

Plex 9/28/18 10:20 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

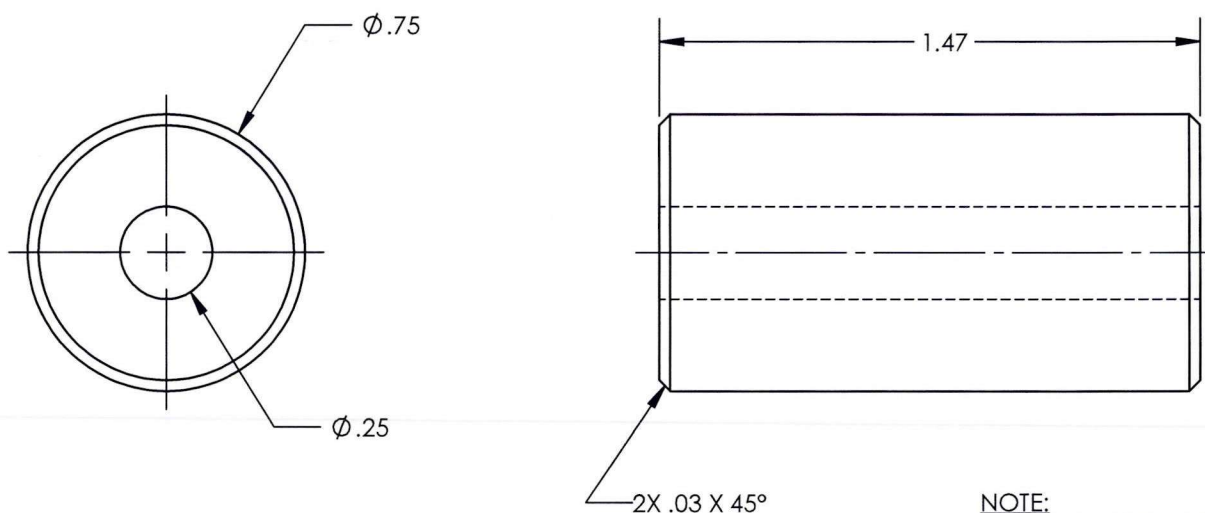
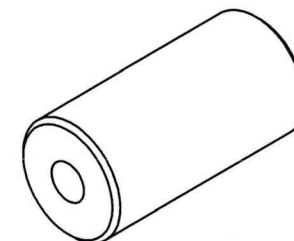
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A	14-0102	ADDED BAG & LABEL NOTE.	7/29/2014	DJN	RW



NOTE:
1. BAG & LABEL WITH BATCH NUMBER.

USED ON
20NR
8NR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 183899
1809-28

DART AEROSPACE	
TITLE ROUND BUMPER	
DWG NO. 20NR-26	REV A
MAT'L POLYURETHANE	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT
.XX ± .01	TREAT
.X ± .1	FINISH
FRACTIONS ± 1/32	SPEC 90A DUROMETER
ANGLES ± 5°	USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45°	
OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 10/14/2005
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			20NR-26	1	ROUND BUMPER	POLYURETHANE	Ø7/8 X 1-5/8